

# RATNA B316NF

## Specially designed stainless steel Electrode with controlled ferrite content 0.5FN

**CLASSIFICATION** : AWS/SFA-5.4: E 316LMn-15

**APPROVAL** :

**CHARACTERISTICS** : An extra low carbon, Basic coated 18Cr/15Ni/6Mn/3Mo/0.2N is normally fully austenitic alloy with a maximum ferrite 0.5FN. Special control of residuals coupled with a high Manganese content ensures freedom from microfissuring cracks.

**APPLICATION** :

- 1) Suitable for welding in critical applications for cryogenic and corrosion resistant service.
- 2) Suitable for similar steels such as UNS S30453 and S31653.
- 3) Electrode also exhibits good corrosion resistance in acids and seawater.
- 4) Suited to the corrosion conditions found in urea synthesis plants.

**RE-DRY CONDITION** : Re-Dry the electrode at 350°C for 1 hrs before use.

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Mo	N	Cu
0.04 max.	5.00- 8.00	0.90 Max	0.030 Max	0.040 Max	18.00- 21.00	15.00- 18.00	2.50- 3.50	0.10- 0.25	0.75 Max.

### ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT	FERRITE (FN)
550	20	-196°C : 50 J	0.5FN

### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	kg./pkt.	kg./Case
2.40	3/ 32"	60-80	2	20
3.20	1/ 8"	80-120	2	20
4.00	5/ 32"	110-150	2	20
5.00	3/ 16"	140-170	2	20

Customer packing on request.